

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022700**Date Inspected:** 15-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

**Bay 1**

This QA inspector observed ZPMC in process of SMAW welding Bike Path Handrail sub-assemblies. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Tian Lei as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 215248

2F/SMAW

**Bay 8**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of performing heat straightening. ZPMC QC inspector Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Fa Wen as the CWI. This QA inspector verified this information for the following location;

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Heat Straightening

HSR1 (B) 10201

SA7047-001 ~ 011

Heat Straightening

HSR1 (B) 10202

SA7535-001 ~ 011

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding. ZPMC QC Wang Zhen was present at this time of this observation and informed this QA inspector of the work that is in process and identified Chen Shi Gang as the CWI. It was stated that ZPMC had 6 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20689

Weld- 3012TR7-001-013, 014

WPS-345-FCAW-1G(1F)-Repair-1

Welder- 059421, 203805

1G/FCAW(ESAB)/CJP

Weld- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 059418

2F/SMAW

Weld- X8523H-001, 002

WPS- B-T-2231-ESAB

Welder- 059403

1G/FCAW/CJP

Weld- 3013TR1-001, 002

WPS- B-T-2231-ESAB

Welder- 059443

1G/FCAW/CJP

Weld- 3013TR2-001, 003

WPS- B-T-2231-ESAB

Welder- 059378

1G/FCAW/CJP

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening. ZPMC CWI Shi Yu was present at this time of this

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observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC This QA inspector verified this information for the following location;

Weld- X3305K-006-001, 002

WPS-B-T-2211-TC-U4b

Welder- 040582

1G/SMAW/CJP

Weld- X3305K-007-001, 002

WPS-B-T-2211-TC-U4b

Welder- 040581

1G/SMAW/CJP

Weld- X3305K-008-001, 002

WPS-B-T-2233-ESAB

Welder- 040533

3G/FCAW/CJP

Weld- X3305K-010-001, 002

WPS-B-T-2211-TC-U4b

Welder- 057220

1G/SMAW/CJP

Heat Straightening

HSR1 (B) 10292

31TR1-001, 31TR2-001, 31TR3

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Hasler, Mike | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Riley, Ken   | QA Reviewer                 |

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